

Work Order ID 83004

Thursday, April 12, 2012 11:16:47 AM

83004

Page 1

Item ID: D3017-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Back Frame Assembly
 Start Date: 4/12/2012 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 4/24/2012 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *P* Date: 12-04-12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3017	Rev B

100 Weld per dwg A/R 4130 rod Batch: M119875 0.00
 Large Fab

100

Large Fab Memo 0.00 *Q* *12-6-20*

Large Fab
 1-Cut D3017-1, D3017-3 and D3017-5 tubes as per Dwg D3017
 2-Bend D3017-1 and D3017-3 tube as per dwg D3017 (DT8598)
 3-Drill holes in D3017-5 Using DT8622
 4-Deburr
 5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598
 6-Drill holes in back frame using DT8621

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC Memo 0.00 *1* *Q* *12-06-20*

Quality Control

W/O:		WORK ORDER CHANGES					
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120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

130

Powdercoat

Powder Coating

Memo

START TIME: 3:00

OVEN TEMPERATURE: 3200F

FINISH TIME: 3:30

0.00

140

QC3- Inspect Part Finish

0.00

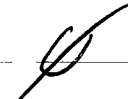

140

QC

Memo

0.00

Quality Control

IX  12/06/20
 1  12/06/20

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <i>G.A</i>	0.00							
150									
Packaging	Memo <i>w/o</i>	0.00				<i>1x</i>			<i>12/06/22</i>
Packaging	<i>83002</i>								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							<i>12/06/25</i>
Quality Control									

MC 12/06/22

Dart Aerospace Ltd

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Picklist Print

Thursday, April 12, 2012 11:16:52 AM

Page 1

Work Order ID: 83004

83004

Parent Item: D3017-041

D3017-041

Parent Item Name: Back Frame Assembly

Start Date: 4/12/2012

Required Date: 4/24/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A01.09.19New issue EC
IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M4130NT0.750W.083

Purchased

No

100

f

40.4770

2.458

2.587368

M4130NT0 750W 083

**

EL 12-6-20

4130 RD Tube .750 x.083W

Location

Loc Qty

Loc Code

MAT033

40.477

117579

16.56

117973

23.917

2.58

M4130NT0.750W.049

Purchased

No

100

f

125.6700

11.125

11.71053

M4130NT0 750W 049

**

EL 12-6-20

4130 RD Tube .750 x.049W

Location

Loc Qty

Loc Code

MAT033

125.67

118772

13.04

120350

67.8

121025

44.83

11.7

D3017-11

Manufactured

No

100

Each

54.0000

2

2

D3017-11

**

EL 12-6-20

cap

Location

Loc Qty

Loc Code

WA021

54

76851

54

2

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D3017-041

D3017-041

Parent Item Name: Back Frame Assembly

Start Date: 4/12/2012

Required Date: 4/24/2012

Start Qty: 1.00

Required Qty: 1.00

D3017-7

Manufactured No

100

Each

10.0000

3

3

D3017-7

EL 12-6-20

Lug

Location

Loc Qty

Loc Code

WA021

10

69166

1

70871

1

70905

8

3

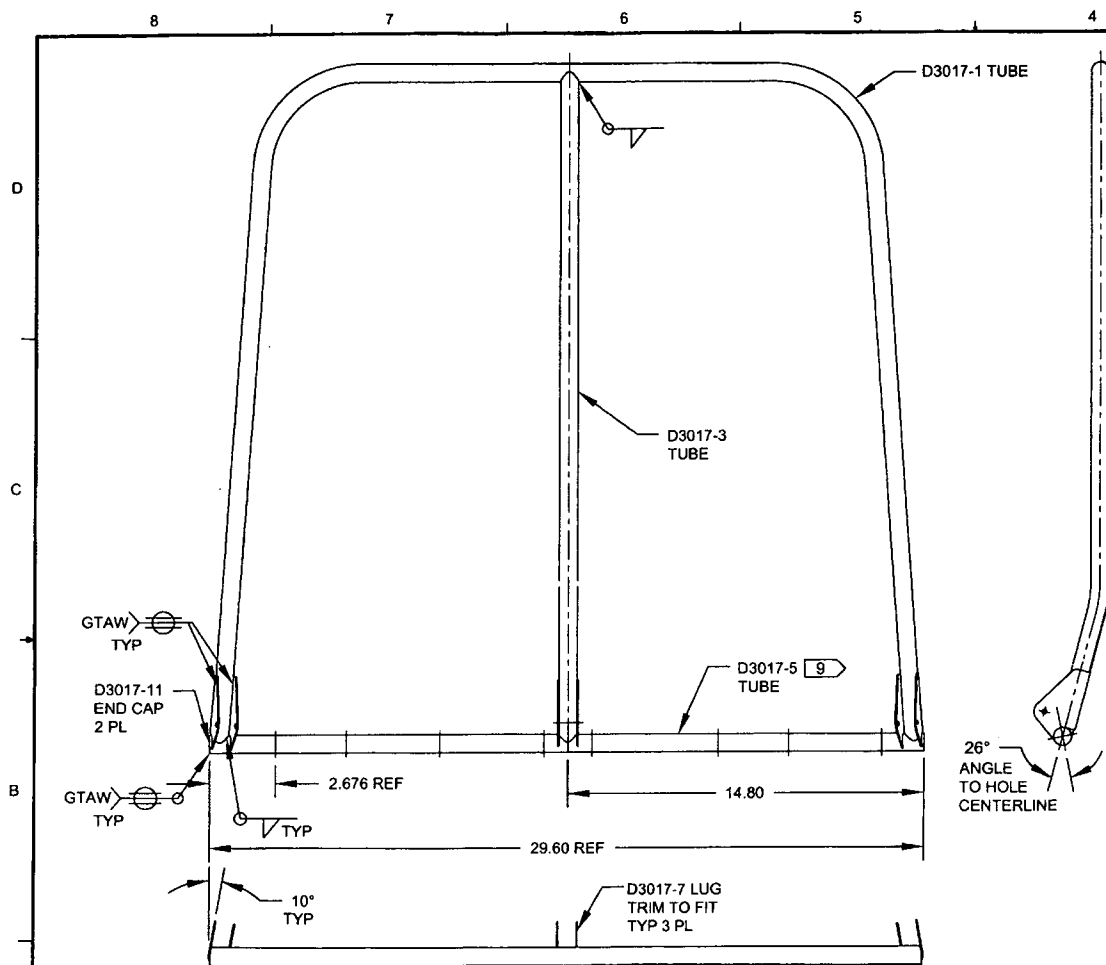
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ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83004

12-04-12 **RELEASED**
2010-02-02
wp

D3017-041 BACK FRAME ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004
- 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

B	REFORMAT DWG. - 5 TUBE WALL THKNS REV'D (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BACK FRAME ASSEMBLY	NTS
DATE	10.01.13	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

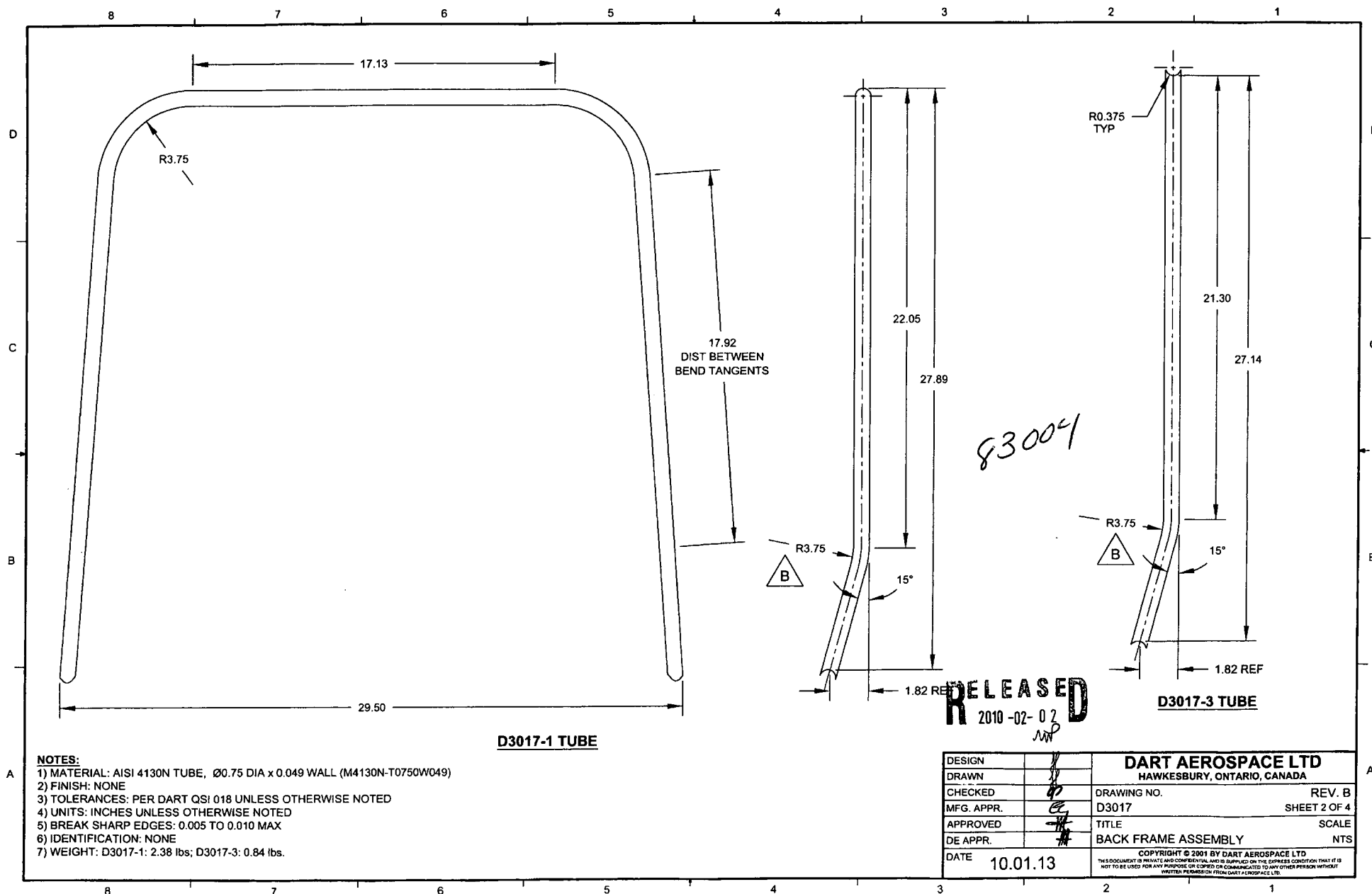
Dart Aerospace Ltd

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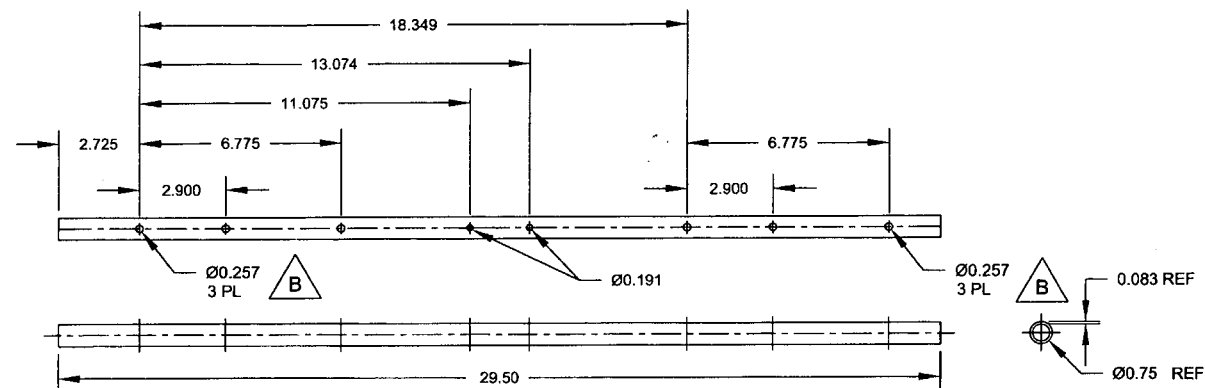
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D3017-5 TUBE

83004

RELEASED
2010-02-02
M

- NOTES:**
- 1) MATERIAL: AISI 4130N TUBE, $\varnothing 0.75$ DIA x 0.083 WALL (M4130N-T0750W083)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.89 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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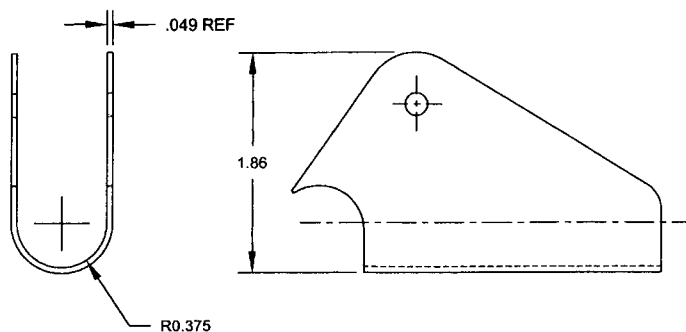
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D

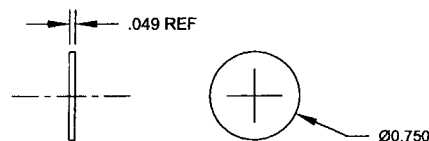
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B

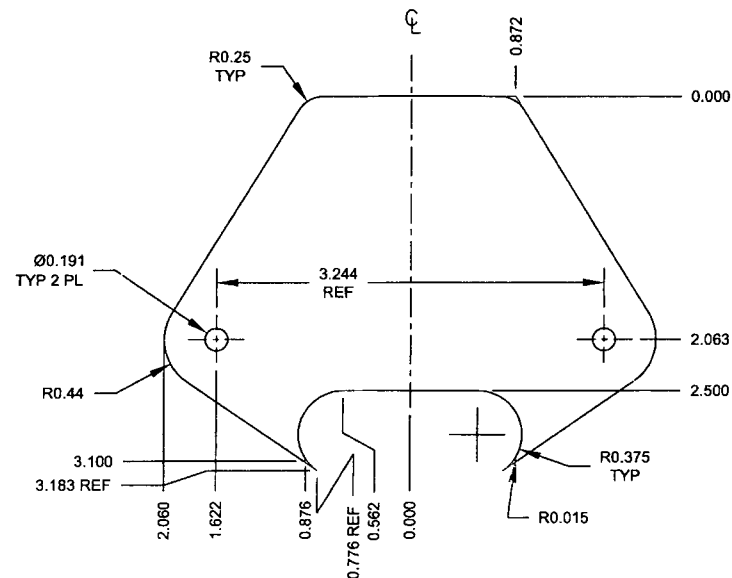
A



D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F



D3017-11 END CAP



D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

83004

RELEASED
2010-02-02
MP

NOTES:

- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
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8 7 6 5 4 3 2 1

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